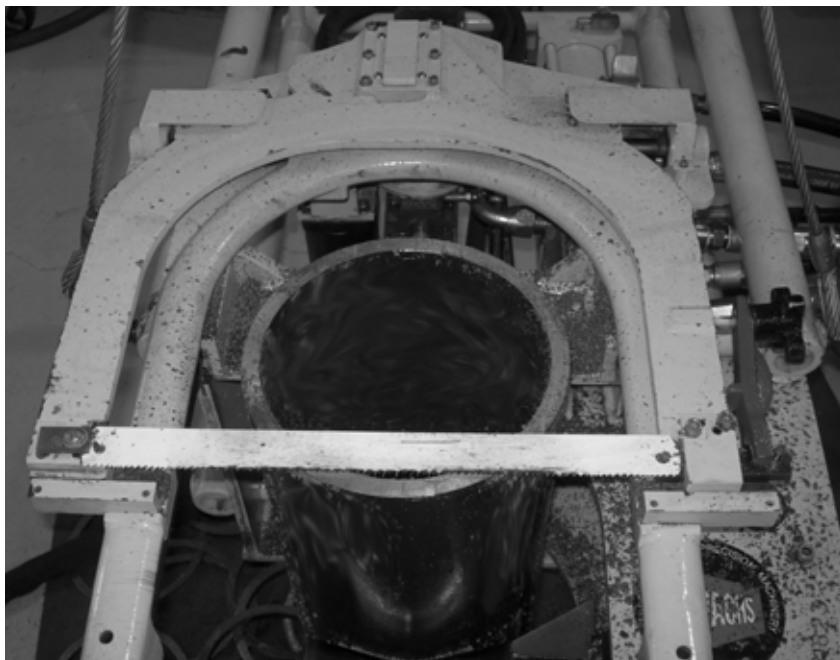




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Autoclamp/Autofeed Guillotine Super C Pipe Saw User's Manual



E.H. Wachs Company Part No. SuperC_06-150-500-MAN
Rev. 1-1111, November 2011

Revision History:
Original June 2007

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Table of Contents

Chapter 1: About This Manual	1
Purpose of This Manual	1
How to Use The Manual	2
Symbols and Warnings	2
Manual Updates and Revision Tracking	3
 Chapter 2: Safety	 5
Operator Safety	5
Protective Equipment Requirements	6
Safety Labels	7
Machine Safety	8
 Chapter 3: Introduction to the Super C Pipe Saw	 9
Usage and Applications	9
Mechanical Overview	10
Machine Specifications	13
Operating Envelope	14
 Chapter 4: Assembly, Disassembly, and Storage	 17
Environmental Requirements	17
Long-Term Storage	17
 Chapter 5: Operating Instructions	 19
Machine Set-Up	19
Positioning the Saw	20
Connecting the Hoses	20
Clamping the Saw to the Workpiece	23
Operation	25
Removing the Saw	30
 Chapter 6: Routine Maintenance	 33
Lubrication	33
Blade Replacement	40
 Chapter 7: Service and Repair	 43
 Chapter 8: Parts Lists and Drawings	 45
 Chapter 9: Accessories	 55

Chapter 10: Ordering Information.....	57
Ordering Replacement Parts.....	57
Repair Information.....	57
Warranty Information.....	58
Return Goods Address.....	58

Chapter 1

About This Manual

PURPOSE OF THIS MANUAL

This manual explains how to operate and maintain the Guillotine Super C Pipe Saw. It includes instructions for set-up, operation, and maintenance, including the optional auto-clamping and autofeed accessories. It also contains parts lists, diagrams, and service information to help you order replacement parts and perform user-serviceable repairs.

Before operating the Guillotine Pipe Saw, you should read through this manual and become familiar with all instructions. At a minimum, make sure you read and understand the following chapters:

- Chapter 1, About This Manual
- Chapter 2, Safety
- Chapter 3, Introduction to the Equipment
- Chapter 5, Operating Instructions
- Chapter 9, Accessories

If you will be performing service or repairs, make sure you read and understand these chapters:

- Chapter 1, About This Manual
- Chapter 4, Assembly and Disassembly
- Chapter 6, Routine Maintenance
- Chapter 7, Service and Repair.

In This Chapter

PURPOSE OF THIS MANUAL
HOW TO USE THE MANUAL
SYMBOLS AND WARNINGS
MANUAL UPDATES AND
REVISION TRACKING

Throughout this manual, refer to this column for warnings, cautions, and notices with supplementary information.

You will also want to refer to Chapter 8, Parts Lists and Drawings.

HOW TO USE THE MANUAL

This manual is organized to help you quickly find the information you need. Each chapter describes a specific topic on using or maintaining your equipment.

Each page is designed with two columns. This large column on the inside of the page contains instructions and illustrations. Use these instructions to operate and maintain the equipment.

The narrower column on the outside contains additional information such as warnings, special notes, and definitions. Refer to it for safety notes and other information.

SYMBOLS AND WARNINGS

The following symbols are used throughout this manual to indicate special notes and warnings. They appear in the outside column of the page, next to the section they refer to. Make sure you understand what each symbol means, and follow all instructions for cautions and warnings.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



NOTE

This symbol indicates a user notice. **Notices** provide additional information to supplement the instructions, or tips for easier operation.

MANUAL UPDATES AND REVISION TRACKING

Occasionally, we will update manuals with improved operation or maintenance procedures, or with corrections if necessary. Revised chapters will be available for customers. If you receive revised chapters for your manual, remove the old chapters from your binder and replace them with the new chapters.

When a manual is revised, we will update the revision history on the title page and at the bottom of the pages in the revised chapters. It is important to put the current title page with the revision history in your manual. This will help you make sure you have all current information.

You may have factory service or upgrades performed on the equipment. If this service changes any technical data or operation and maintenance procedures, we will include revised sections of the manual when we return the equipment to you. Remove the old chapters from your manual and replace them with the revised chapters.

Current versions of E.H. Wachs Company manuals are also available in PDF format. You can request an electronic copy of this manual by emailing customer service at sales@wachSCO.com.

Chapter 2

Safety

.....

The E.H. Wachs Company takes great pride in designing and manufacturing safe, high-quality products. We make user safety a high priority in the design of all our products.

Read this chapter carefully before operating the Guillotine Super C pipe saw. It contains important safety instructions and recommendations.

OPERATOR SAFETY

Follow these guidelines for safe operation of the equipment.

- **READ THE OPERATING MANUAL.** Make sure you understand all setup and operating instructions before you begin.
- **INSPECT MACHINE AND ACCESSORIES.** Before starting the machine, look for loose bolts or nuts, leaking lubricant, rusted components, and any other physical conditions that may affect operation. Properly maintaining the machine can greatly decrease the chances for injury.
- **ALWAYS READ PLACARDS AND LABELS.** Make sure all placards, labels, and stickers are clearly legible and in good condition. You can purchase replacement labels from E.H. Wachs Company.
- **KEEP CLEAR OF MOVING PARTS.** Keep hands, arms, and fingers clear of all rotating or moving parts.

In This Chapter

OPERATOR SAFETY

SAFETY LABELS

MACHINE SAFETY

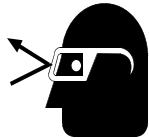


Look for this symbol throughout the manual. It indicates a safety warning.


Always turn machine off before doing any adjustments or service.

- **SECURE LOOSE CLOTHING AND JEWELRY.** Secure or remove loose-fitting clothing and jewelry, and securely bind long hair, to prevent them from getting caught in moving parts of the machine.
- **KEEP WORK AREA CLEAR.** Keep all clutter and nonessential materials out of the work area. Only people directly involved with the work being performed should have access to the area.
- **DO NOT OPERATE IN POTENTIALLY EXPLOSIVE ENVIRONMENTS.** The Guillotine saw can create sparks, which can cause an explosion in the presence of flammable or explosive materials.

Protective Equipment Requirements

	WARNING Always wear impact resistant eye protection while operating or working near this equipment.
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For additional information on eye and face protection, refer to Federal OSHA regulations, 29 Code of Federal Regulations, Section 1910.133., Eye and Face Protection and American National Standards Institute, ANSI Z87.1, Occupational and Educational Eye and Face Protection. Z87.1 is available from the American National Standards Institute, Inc., 1430 Broadway, New York, NY 10018.

	CAUTION Personal hearing protection is recommended when operating or working near this tool.
---	--

Hearing protectors are required in high noise areas, 85 dBA or greater. The operation of other tools and equipment in the area, reflective surfaces, process noises, and resonant structures can increase the noise level in the area. For additional information on hearing protection, refer to Federal OSHA

regulations, 29 Code of Federal Regulations, Section 1910.95, Occupational Noise Exposure and ANSI S12.6 Hearing Protectors.

SAFETY LABELS

There are two safety labels on the Super C Guillotine saw. These are illustrated in Figure 2-1 and Figure 2-2.



Figure 2-1. Observe the warning label for moving parts hazards.



Figure 2-2. Observe the warning label for blade hazard.

MACHINE SAFETY

To avoid damaging the Guillotine Super C, follow these usage guidelines.

- Do not exceed 1800 psi hydraulic pressure.
- Lubricate the machine according to the recommendations in Chapter 6.
- Before starting the machine, make sure the feed drive is retracted so that the blade is not in contact with the surface being cut.

Chapter 3

Introduction to the Super C Pipe Saw

.....

Read this chapter carefully to become familiar with the components of the Guillotine Super C pipe saw.

USAGE AND APPLICATIONS

The Guillotine Super C pipe saw is designed for cold-cutting pipes of any material from 2" to 12" diameter, as well as solids such as bar stock and rails up to 12-3/4" wide. The saw has a "V"-saddle base that ensures square alignment with the workpiece, and an optional autoclamping mechanism simplifies installation on the workpiece. The Guillotine Super C will cut approximately 1.3 diameter inch per minute.

The reciprocating motion of the Guillotine saws lifts the blade from the cut on the return stroke, greatly increasing blade life. Blades are easily changed out when worn.

Guillotine saws are available for hydraulic, electric, and pneumatic power sources. Available accessories include hydraulic autoclamping for fast setup in difficult environments (such as underwater cutting) and adjustable autofeed for automated cutting.

In This Chapter

USAGE AND APPLICATIONS

MECHANICAL OVERVIEW

MACHINE SPECIFICATIONS

OPERATING ENVELOPE

MECHANICAL OVERVIEW

Figure 3-1 through Figure 3-3 illustrate the mechanical components of the Super C pipe saw. Figure 3-4 shows the hydraulic connector bulkhead. Refer to them during set-up instructions for identifying the parts of the machine.

The topside control unit (TCU), which is used for control of the hydraulic Super C saw, is shown in Figure 3-5.

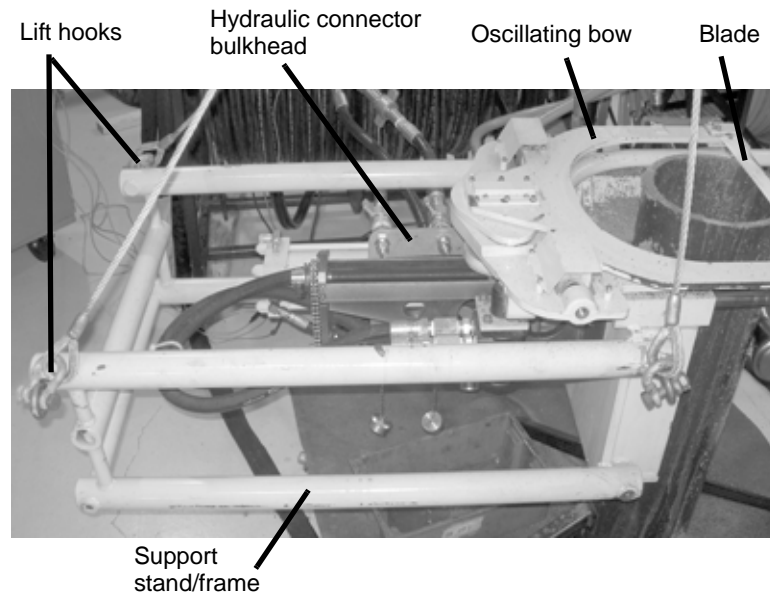


Figure 3-1. The photo illustrates the mechanical components of the Super C pipe saw.

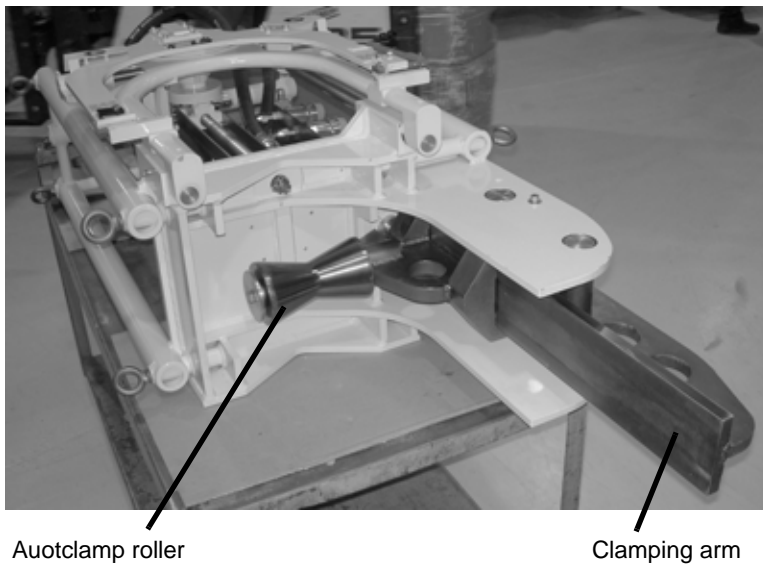


Figure 3-2. Autoclamp components of the Super C.

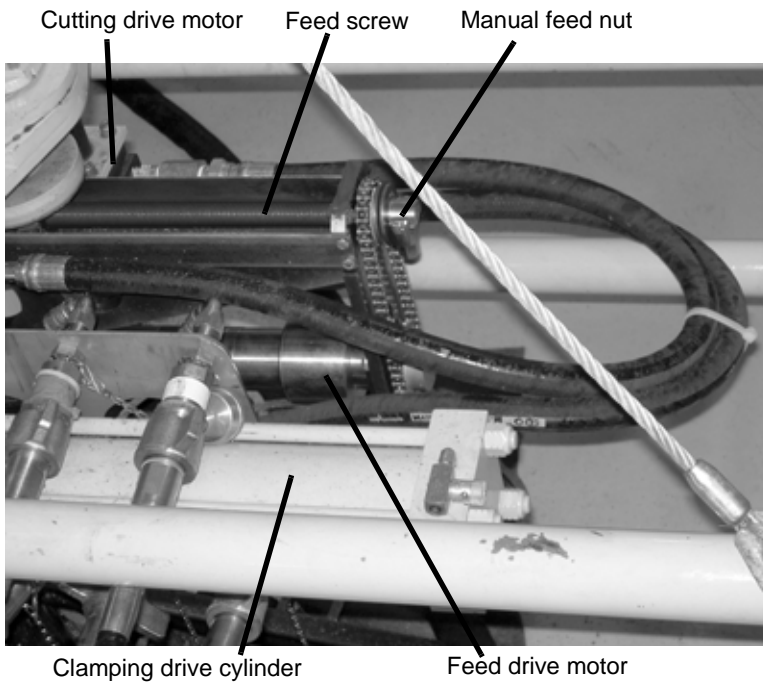


Figure 3-3. The Super C drive components are illustrated.

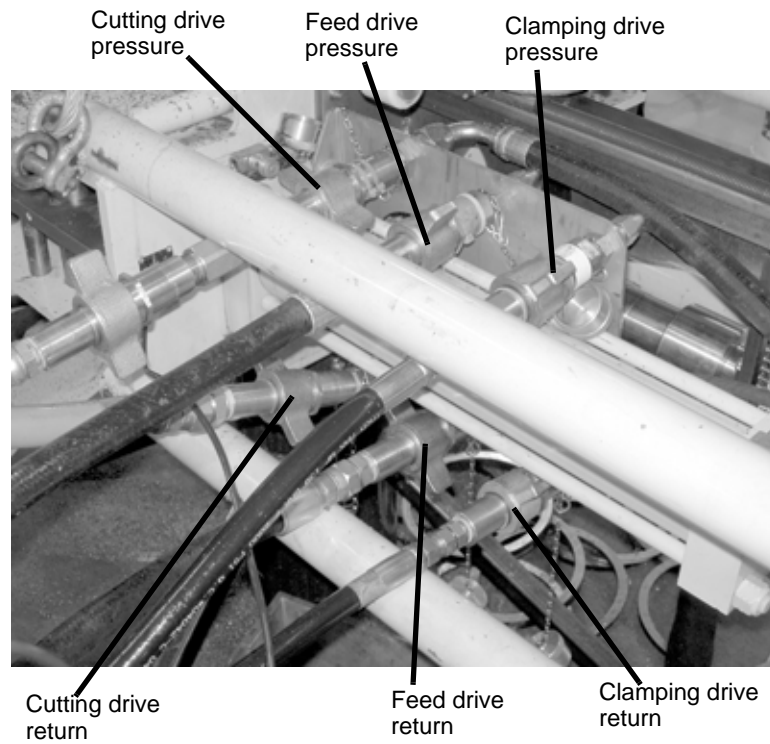


Figure 3-4. The photo shows the hydraulic connector bulkhead.

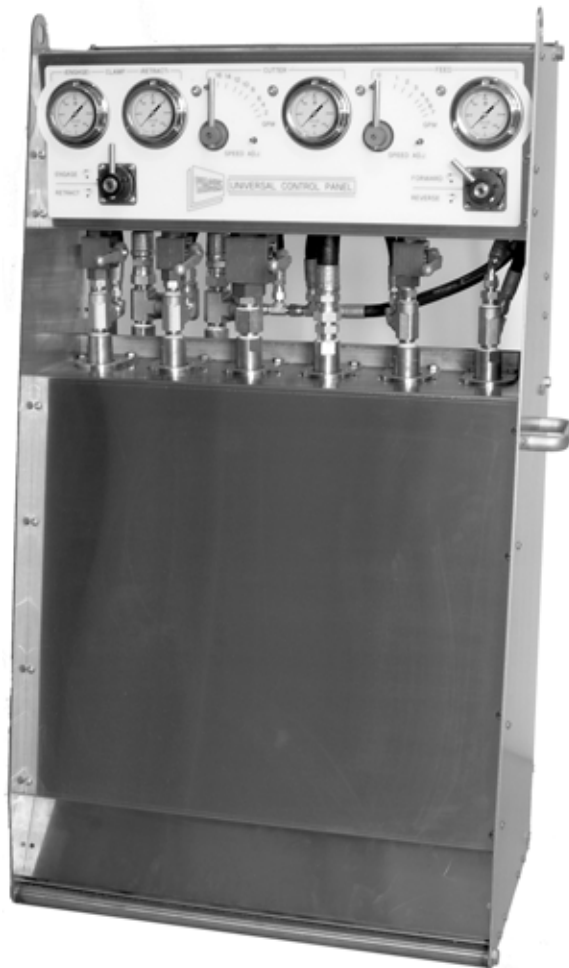


Figure 3-5. The photo shows the topside control unit.

MACHINE SPECIFICATIONS

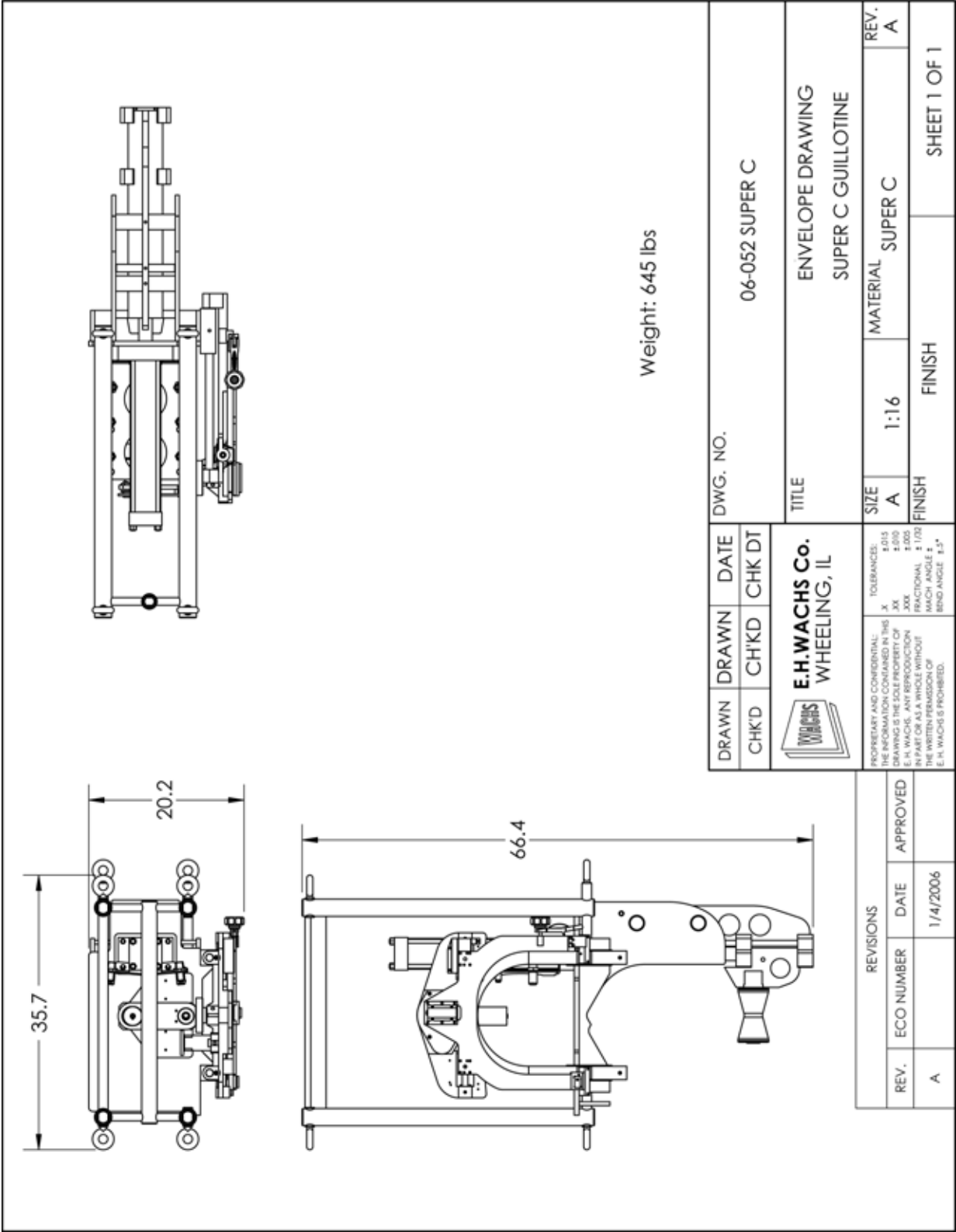
The following specifications are for the Guillotine Super C with autofeed and autoclamping accessories installed.

Capacity:	2"-12" (51-305 mm) diameter pipe; solids up to 12-3/4" (324 mm)
Drive:	Hydraulic, 15 gpm @ 1800 psi
Length:	66.3" (1684 mm)
Width:	31.7" (805 mm)
Height:	20.2" (513 mm)

Lubrication:	Grease fittings at all wear points; auto-clamp rail
Finish:	Paint
Blades:	General purpose and heavy duty
Feed rate:	Variable up to 1.3" per minute
Noise level:	72 dBA (continuous A-weighted sound pressure at work station) 90 dBA (peak C-weighted maximum sound pressure) 86 dBA (sound power level emitted by machine)

OPERATING ENVELOPE

The drawing on the next page illustrates the operating envelope for the Super C Guillotine.



Chapter 4

Assembly, Disassembly, and Storage

The Guillotine Super C pipe saw is factory assembled and ready for set-up. Machines without the optional lifting frame are shipped and stored in a steel case. Machines equipped with the lifting frame are shipped on a skid.

ENVIRONMENTAL REQUIREMENTS

The Guillotine Super C pipe saw can be used in any industrial or field service environment, including underwater. The machine can be used for dry cutting or with coolant applied to the workpiece.

LONG-TERM STORAGE

If you will be storing the Guillotine Super C, take the following steps to prepare it:

- Reverse the feed drive to the end of travel.
- Remove the blade.
- Make sure the machine is thoroughly cleaned and cleared of chips and debris.
- Spray the machine with a rust preventative.
- Grease all fittings according to the instructions in Chapter 6.
- Secure the machine in its case, if one is supplied.

In This Chapter

ENVIRONMENTAL
REQUIREMENTS

LONG-TERM STORAGE

Chapter 5

Operating Instructions

The Guillotine pipe saw can be installed on a pipe in any orientation—horizontal, vertical, or at an angle. Once the saw is clamped into place, you will release tension on the lift to allow the clamping mechanism to support the saw.

Refer to Chapter 3 if necessary for identification of the machine’s components. The Super C is operated from the topside control unit (TCU); Figure 5-1 shows the instruction panel on the top of the TCU.

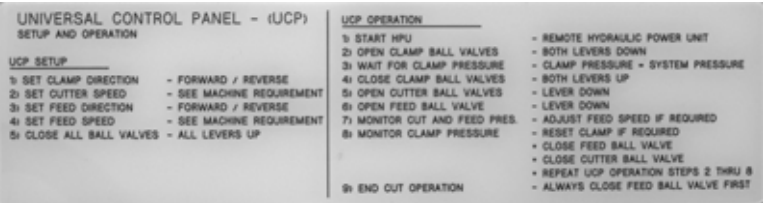


Figure 5-1. The instruction label on top of the TCU provides brief instructions for operating the saw.

MACHINE SET-UP

Before lifting the Guillotine Super C, make sure the feed drive is at its starting point. (The saw bow should be retracted all the way back from the V saddle.) Ensure that the blade is sharp; install a new blade if necessary (see Chapter 6 for instructions).

In This Chapter

- MACHINE SET-UP
- OPERATION
- REMOVING THE SAW

Positioning the Saw

1. The Super C without the lift frame can be lifted and positioned by two operators. For the configuration with the lifting frame, connect cables from a crane to the lift hooks on the frame, as shown in Figure 5-2.

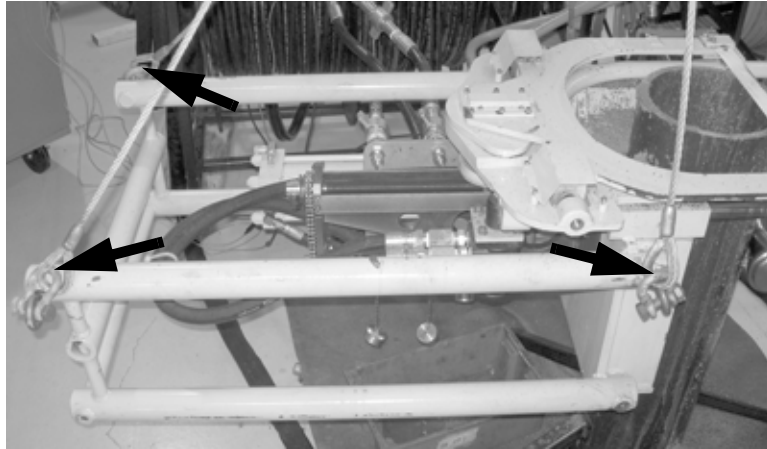


Figure 5-2. There are 4 lift hooks on the lifting frame (3 shown). Use all 4 hooks to mount the saw horizontally on a vertical pipe. Use the 2 hooks at the end (left side) of the frame to mount the saw vertically on a horizontal pipe.

WARNING:

The saw may slide or shift abruptly when it is lifted. Proceed slowly and reposition the lift if necessary to keep it over the saw's center of gravity.



2. Lift the saw carefully, positioning the crane so that it is over the center of gravity as you pick it up. If you are lifting from the top of the saw and the other end starts to slide, stop and reposition the lift.
3. Move the saw into position on the pipe so that the V saddle is against the pipe at the cut position. The saw should be close to square with the pipe; the clamping mechanism will precisely square it.

Connecting the Hoses

1. Wipe all hose couplers with a clean, lint free cloth before making connections.
2. Connect the hoses from the hydraulic power unit (HPU) to the HPU fittings on the back of the topside control unit (TCU).

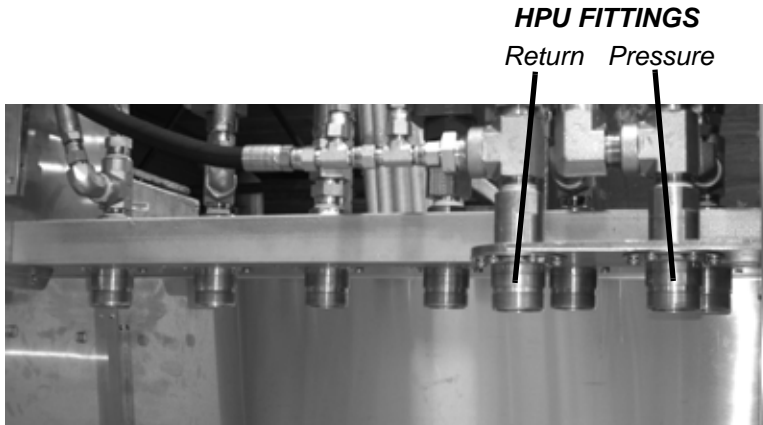
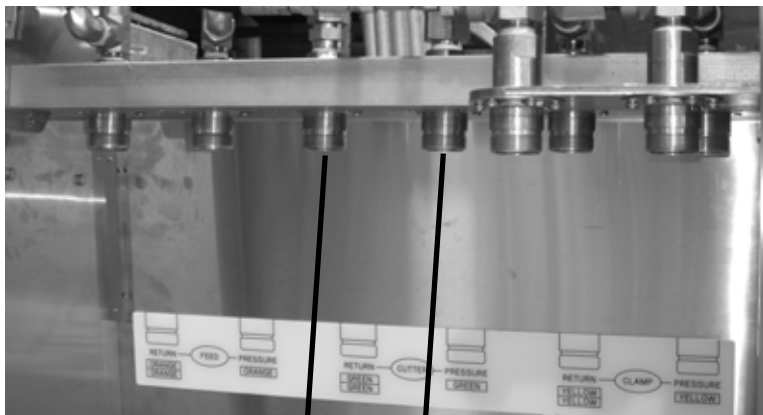


Figure 5-3. HPU hose fittings on the back of the control unit.

3. Connect the cutting drive hose set from the machine or from the hose reel to the cutting drive fittings on the back of the TCU. The hoses and fittings are color coded.



Return Pressure

CUTTER DRIVE

Figure 5-4. Connect the cutting drive hoses to the TCU.

4. If the Guillotine has a hydraulic clamping mechanism, connect the clamping drive hose set to the clamping drive fittings on the back of the TCU. The hoses and fittings are color coded.



Figure 5-5. Connect the clamping drive hoses to the TCU (for machines with hydraulic clamping mechanism).

5. Connect the feed drive hose set from the machine or from the hose reel to the feed drive fittings on the back of the TCU.

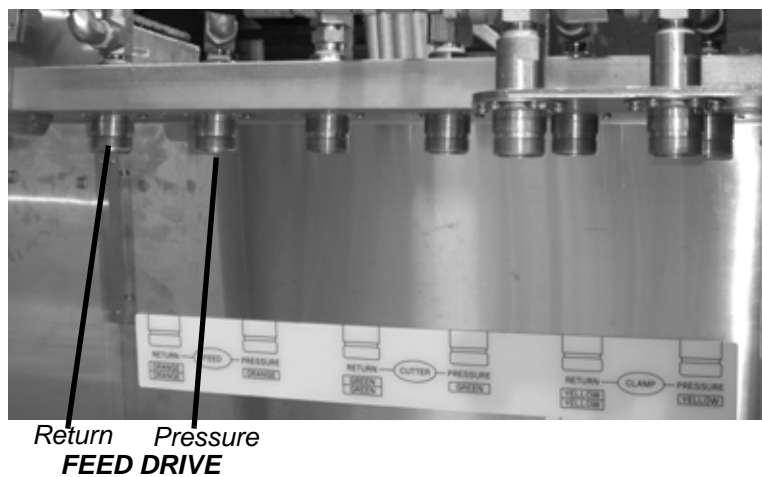


Figure 5-6. Feed drive connectors (for machines with hydraulic feed drives).

6. Connect the hoses from the TCU or hose reel to the fittings on the saw bulkhead as shown in Figure 5-7.

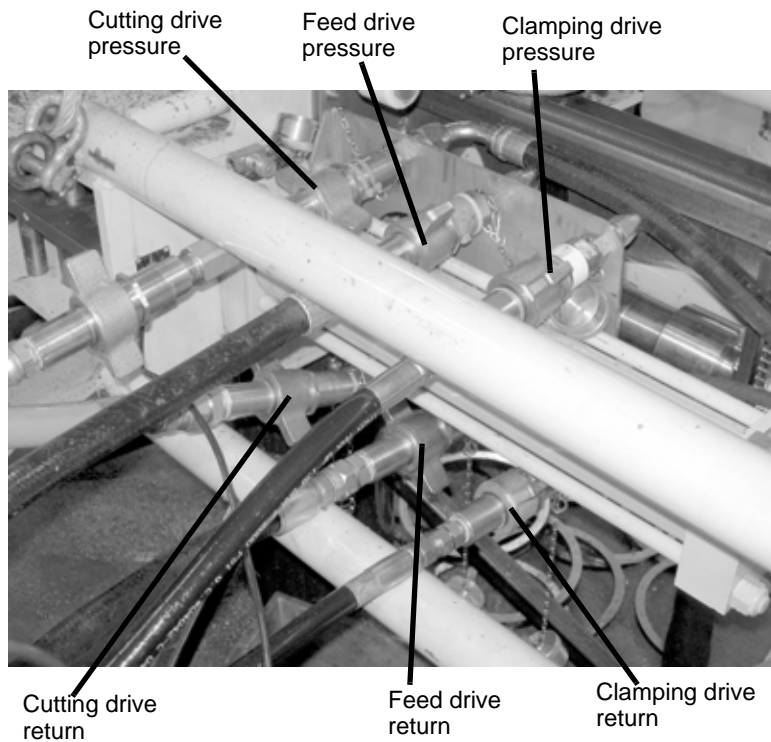


Figure 5-7. Connect the hoses from the TCU to the saw as shown.

Clamping the Saw to the Workpiece

1. Position the saw at the cutting location on the pipe, with the saddle against the pipe surface.
2. Start the hydraulic power unit.
3. Make sure that the clamping drive levers and the cutting drive lever on the TCU are in the closed (up) position, as shown in Figure 5-8.
4. Set the clamping direction lever on the TCU to the ENGAGE position.

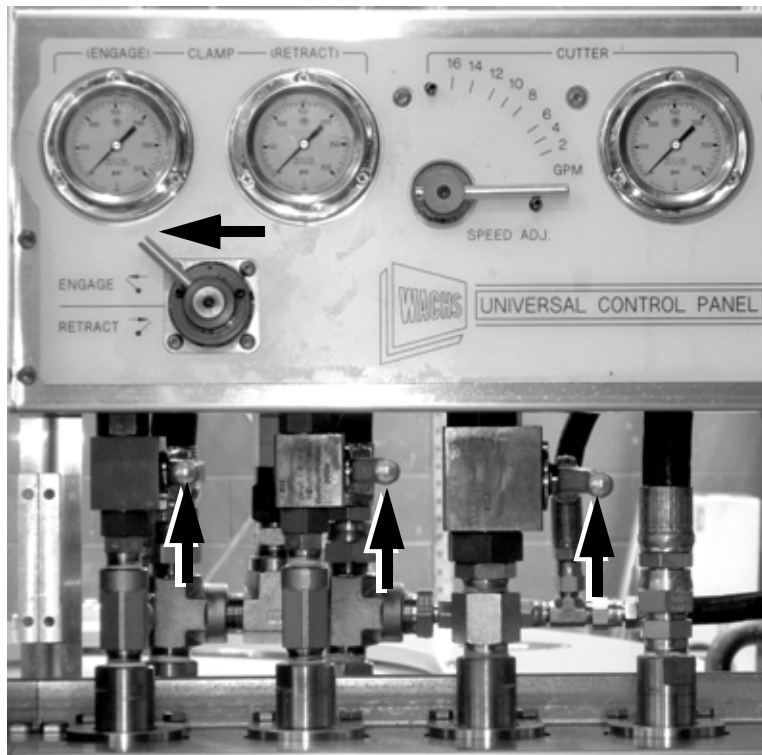


Figure 5-8. Before clamping, make sure that both clamping levers and the cutting lever are in the up position, and that the clamping direction lever is in the ENGAGE position.

5. Open both clamping drive levers (down position) at the same time to engage the autoclamp drive. When the clamp pressure equalizes with the system pressure, the clamp is fully engaged against the pipe.

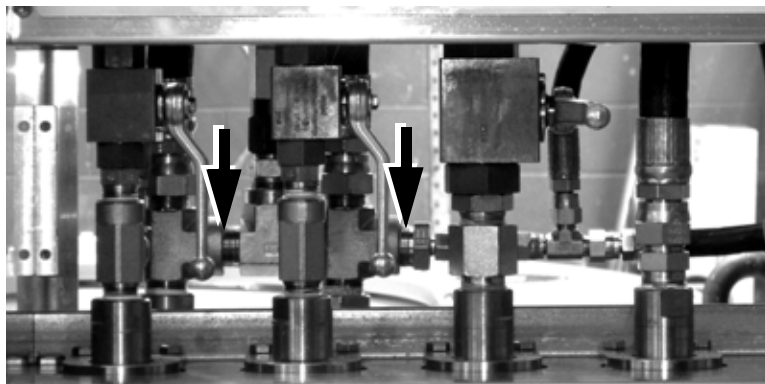


Figure 5-9. Put both clamping levers down at the same time to engage the clamping drive.

6. Close both clamping drive levers (up position) at the same time. The valves will hold pressure on the clamping drive to keep the saw clamped on the pipe.

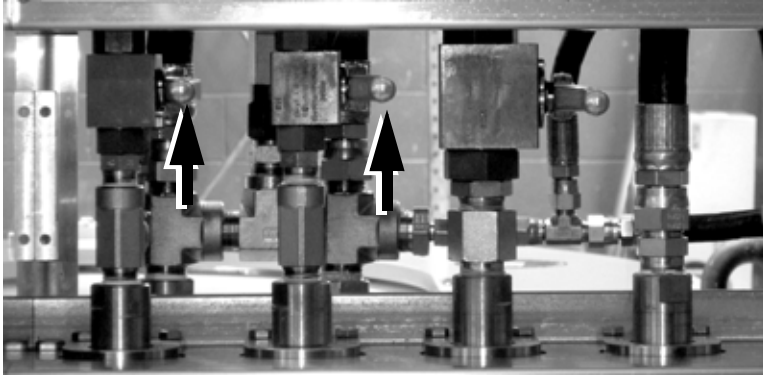


Figure 5-10. When the clamping drive is fully engaged (clamping pressure equals system pressure), return both clamping levers to the up position.

7. Slightly lower the crane holding the saw to allow the clamp to hold the saw's weight. Leave the crane attached to the saw.

OPERATION

The Super C is designed to be used in any environment, including underwater. If dry cutting, use coolant to increase blade life and make cutting easier.

Make sure that the pipe being cut is supported securely on both sides of the saw.

1. Make sure the cutting drive speed control lever is set to 0.



CAUTION: Make sure the pipe is supported securely on both sides of the saw.



WARNING: Make sure all personnel and loose objects are clear of the machine during cutting.



Figure 5-11. Set the cutting drive speed lever to 0 before starting the saw.

2. Open the cutting drive lever (down position).

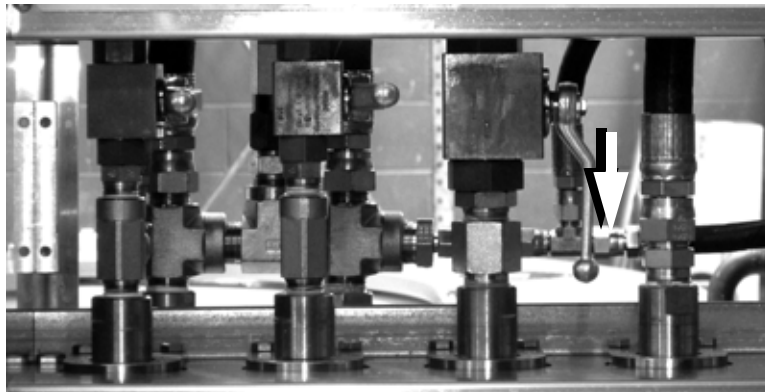


Figure 5-12. Push the cutting drive lever down to open it.

3. Move the cutting drive speed lever up gradually. When sufficient flow reaches the saw, the saw bow will begin the cutting motion.



Figure 5-13. Push the cutting speed lever up slowly until the saw motion begins.

4. Set the feed direction lever to the FORWARD position, as shown in Figure 5-14.
5. Open the feed drive lever by pushing it down.
6. Adjust the feed speed lever until the feed motion starts. Set the lever to the desired speed.

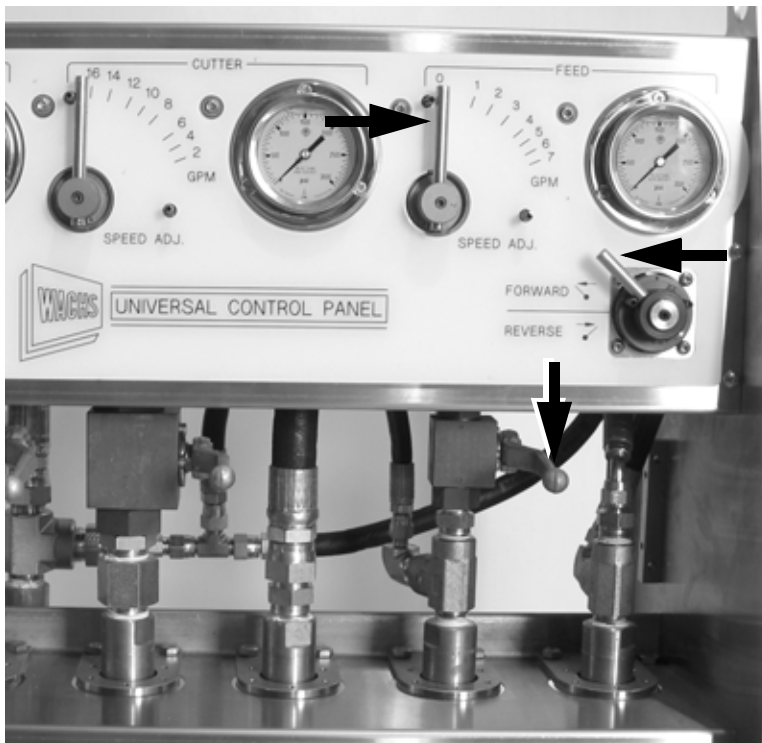


Figure 5-14. With the feed direction lever in the FORWARD position, move the feed drive lever (shown here in the up position) down to start the drive. Then move the feed speed lever to start flow to the feed drive.

7. Set the cutting drive lever for the speed you want. Typically, you can set it to the maximum.



Figure 5-15. Set the cutting speed lever to the desired cutting speed.

8. Allow the saw to operate at a slow feed rate until the blade has parted through the near wall of the pipe.

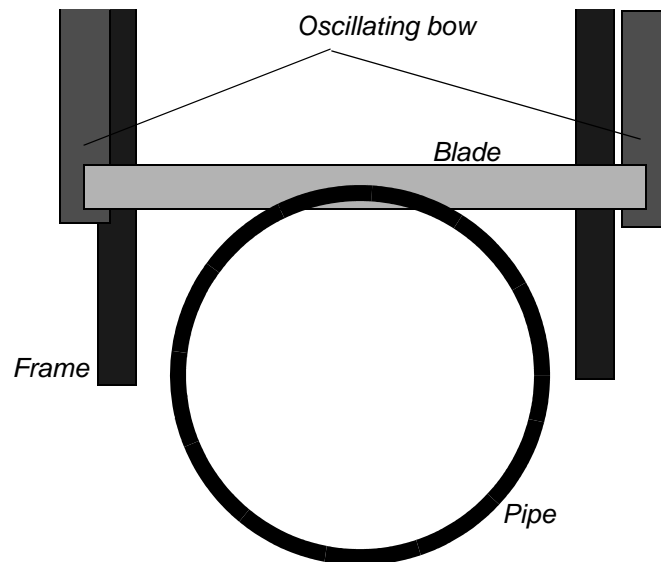


Figure 5-16. Cut at a slow feed rate until the blade parts through the wall of the pipe.

9. After the blade has parted the near wall, you can speed up the feed rate by adjusting the feed speed lever. You may need to slow the rate down if you are cutting an internal casing. Reduce the feed speed if the machine starts to bind or chatter, or if you see the blade deflecting as it cuts.
10. As the blade approaches the far wall of the pipe, slow the feed rate to the setting used at the start. Finish the cut at this feed rate.

11. When the cut is complete, move the feed speed lever back to 0 to stop the feed motion.



Figure 5-17. Stop the feed motion by setting the feed speed lever back to 0.

12. Move the feed drive lever back to the up position.

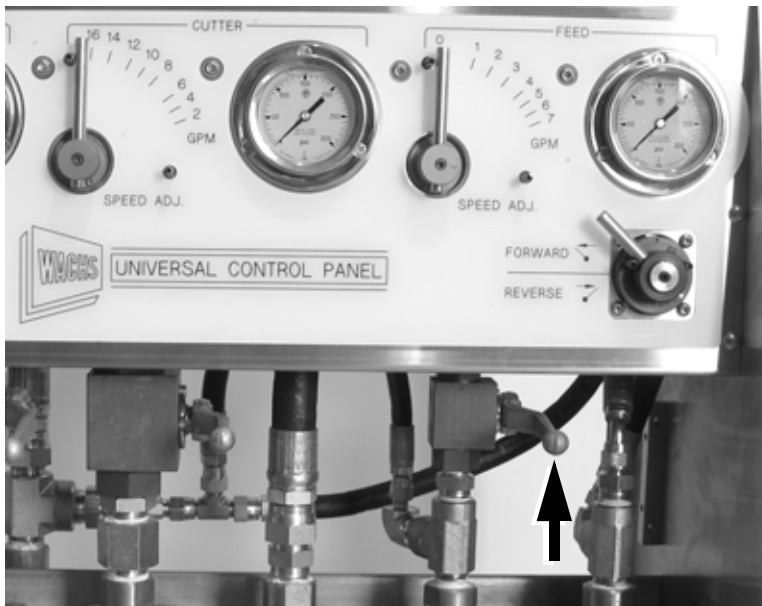


Figure 5-18. Move the feed drive lever up to stop the feed motion.

13. Set the cutting speed lever back to 0, and pull the cutting drive lever back up to the off (up) position.

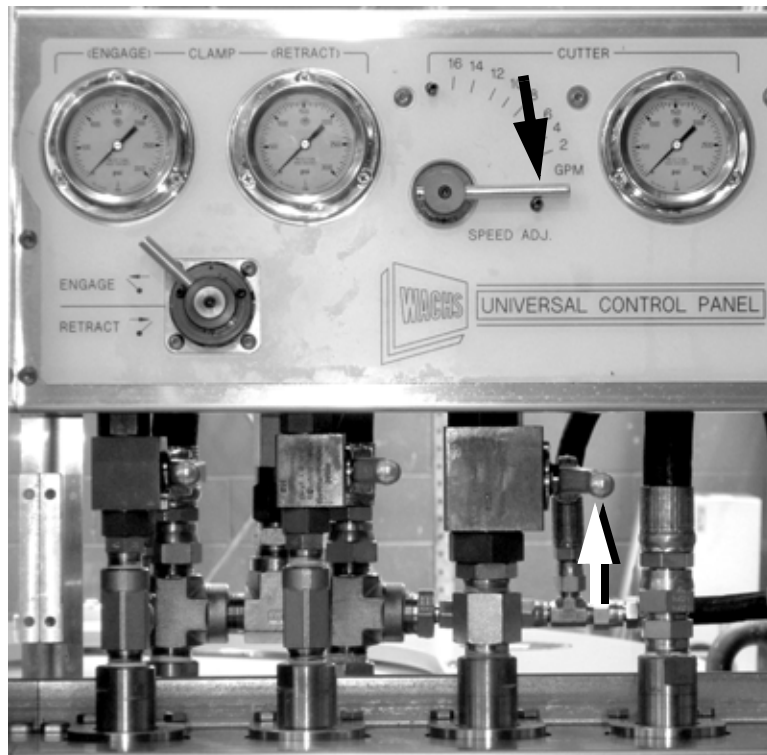


Figure 5-19. When the cut is complete, set the cutting speed lever back to 0. Then return the cutting drive lever to the off (up) position.

14. To reverse the feed and move the saw bow back to the start position, set the feed direction lever to the REVERSE position and use the feed drive lever to operate the drive. You may have to remove the blade first to prevent it from binding on the pipe.

REMOVING THE SAW

1. Slowly raise the crane holding the saw until there is just enough tension to hold the saw in place.
2. Set the clamping direction lever to the RETRACT position.



Figure 5-20. Set the clamping direction lever to the RETRACT position.

3. Open both clamping drive levers (down position) at the same time to retract the autoclamp drive. When the clamp pressure equalizes with the system pressure, the clamp is fully retracted.

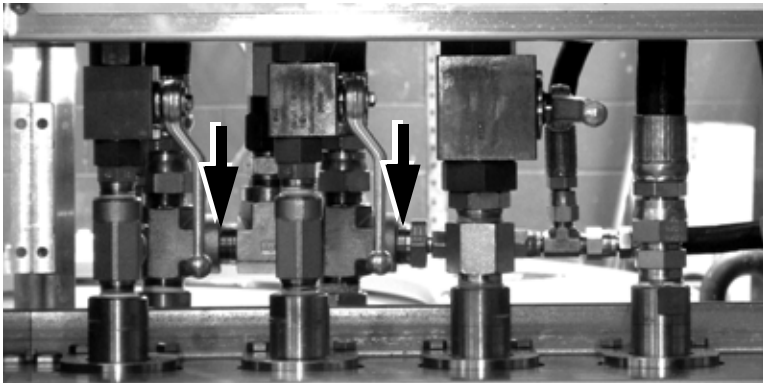


Figure 5-21. Put both clamping levers down at the same time to retract the clamping drive.

4. Close both clamping drive levers (up position) at the same time.

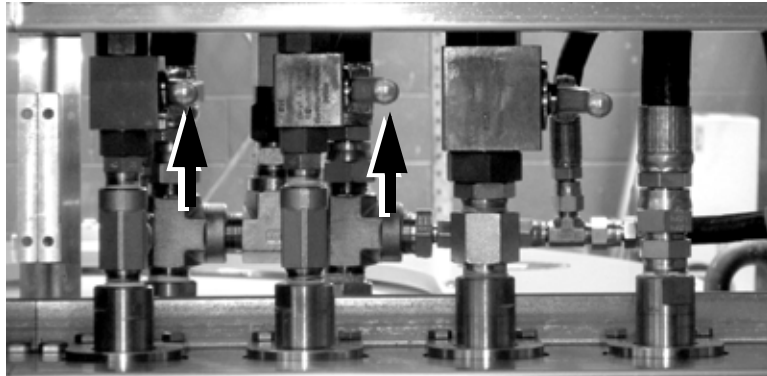


Figure 5-22. When the clamping drive is fully retracted (clamping pressure equals system pressure), return both clamping levers to the up position.

5. Set the clamping direction lever back to the ENGAGE position for the next operation.



Figure 5-23. When the clamp has been retracted, move the clamping direction lever back to the ENGAGE position.

6. Use the crane to remove the saw from the workpiece.
7. If you are finished with the saw, turn off the HPU. Set the saw in its storage location and disconnect the hoses.

Chapter 6

Routine Maintenance

LUBRICATION

There are eleven grease fittings on the Super C Guillotine with autoclamp and autofeed accessories. There are several other mechanical components that require lubrication. All of these grease points are illustrated in this section.

Apply grease at least every 10 hours of machine operation. If you are using the machine in a dirty environment, clean exposed surfaces (such as the feed screw and reciprocating shafts) periodically and then apply fresh grease.

If you are using the machine in a subsea environment, grease it completely after bringing it topside and cycle the machine mechanically to distribute the grease to all surfaces.

1. Grease the guide shaft block fittings on both sides of the saw frame.

In This Chapter

LUBRICATION

BLADE REPLACEMENT



Figure 6-1. The guide shaft blocks on both sides of the saw frame have grease fittings.

2. Grease the three fittings in the drive housing.

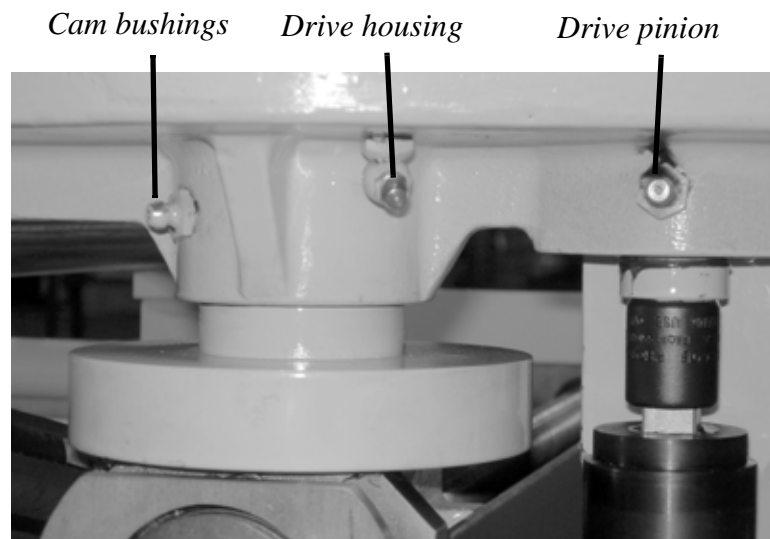


Figure 6-2. Grease the three drive fittings.

3. Grease the fitting on the feed screw block.

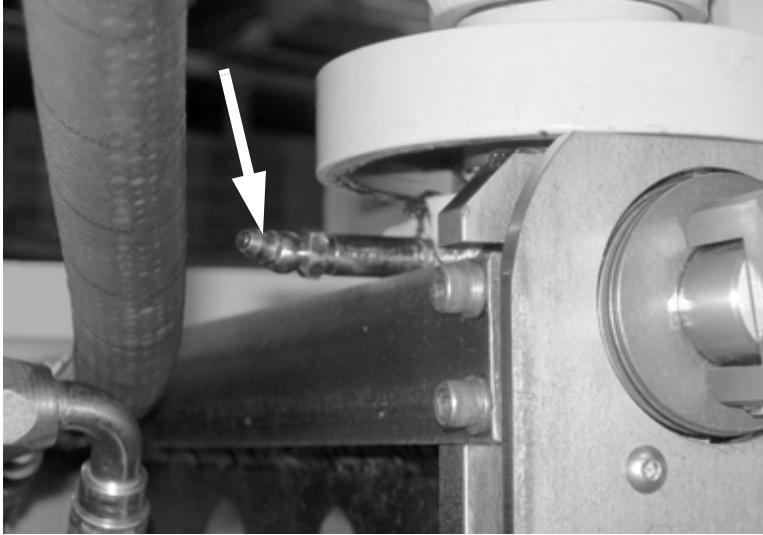


Figure 6-3. Grease the feed screw fitting.

4. Grease the fitting on the feed motor.

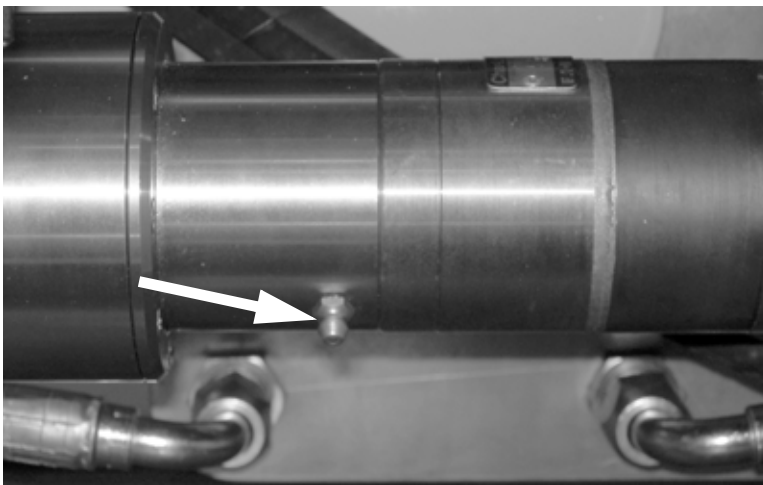


Figure 6-4. Grease the feed motor fitting.

5. Grease the fitting for the upper feed screw bushing, under the side of the saw frame.

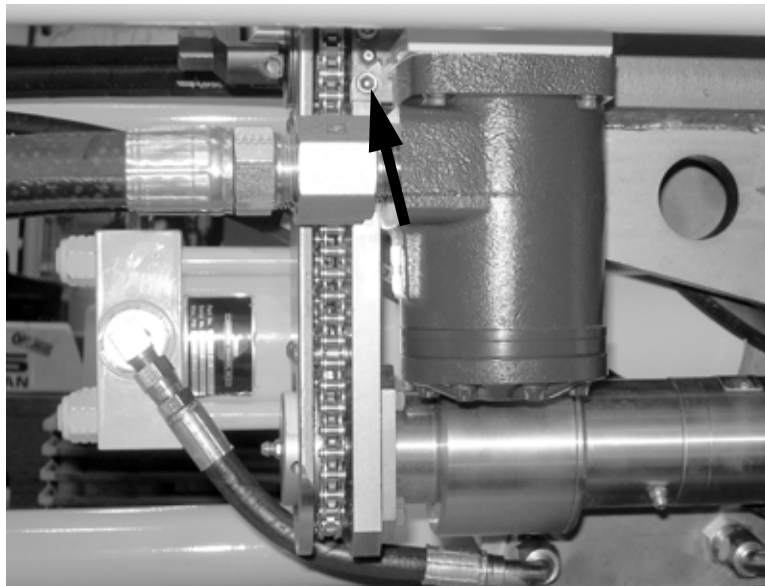


Figure 6-5. Grease the upper feed screw bushing fitting.

6. Grease the feed gearbox fitting on the feed motor.



Figure 6-6. Grease the feed gearbox fitting.

7. There is a grease fitting under the yoke grease cover on the top of the saw bow. Remove the four screws holding the cover and grease the fitting. Replace the cover and the screws.

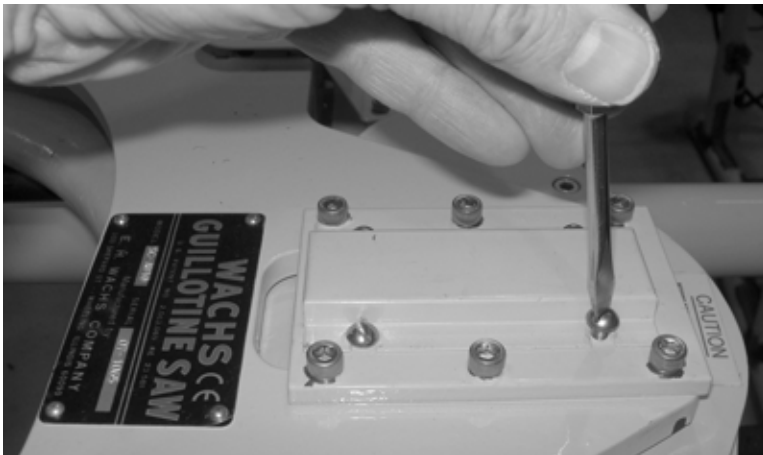


Figure 6-7. Remove the four screws holding the grease cover on the yoke.

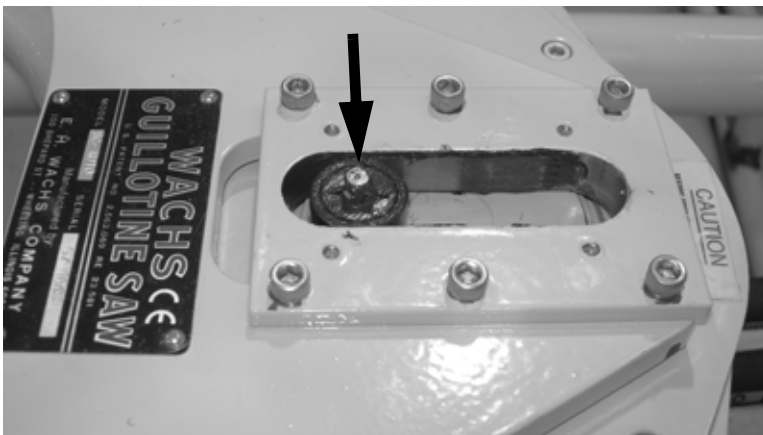


Figure 6-8. Grease the cam roller fitting under the cover.

8. Grease the fitting on the autoclamp roller.

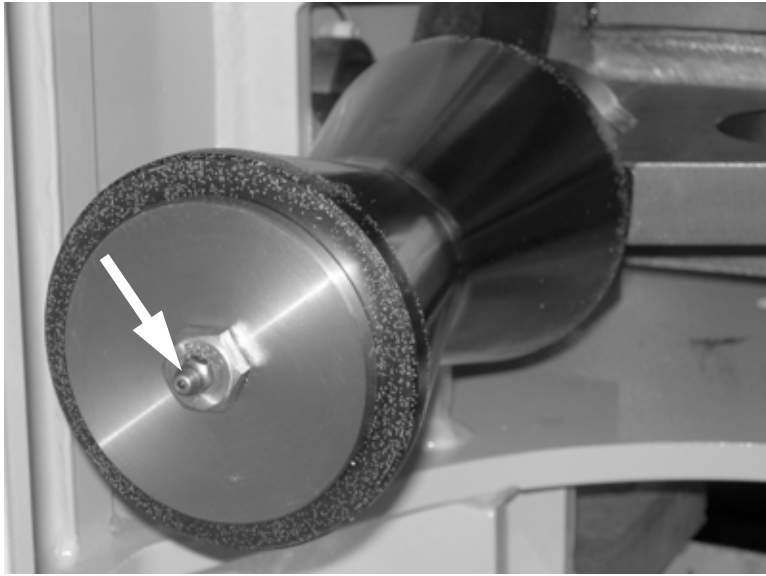


Figure 6-9. Grease the autoclamp roller fitting.

9. Apply grease directly to the autoclamp rail.

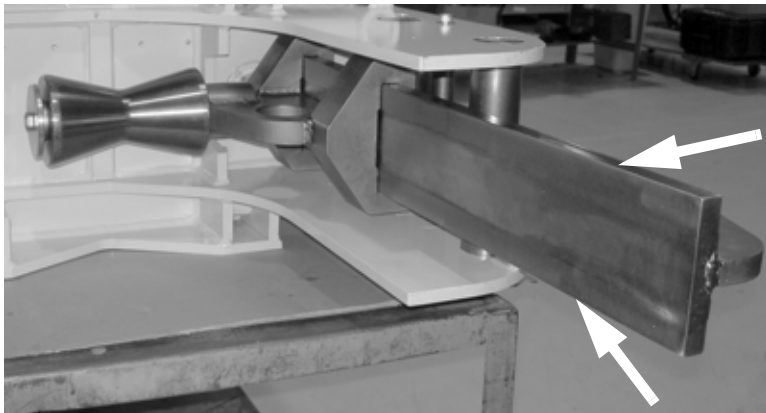


Figure 6-10. Grease the autoclamp rail along the entire length of the top and bottom.

10. Apply grease directly to the bow guides on the saw frame.

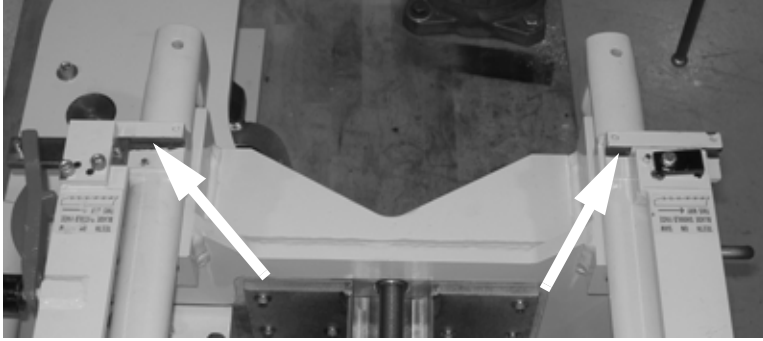


Figure 6-11. Grease the saw bow guides.

11. Apply grease directly to the saw bow reciprocating shafts.

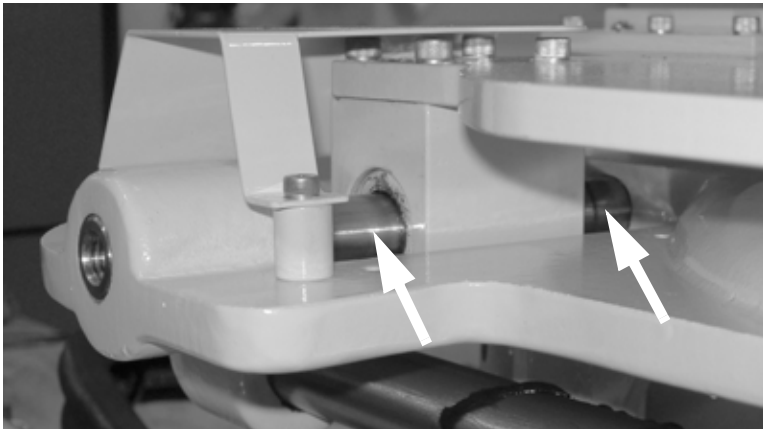


Figure 6-12. Grease the reciprocating shafts under the saw bow (one shaft shown). There is one shaft on each side of the saw bow.

12. Apply grease directly to the feed screw.



Figure 6-13. Grease the feed screw.

BLADE REPLACEMENT

Check the sharpness of the blade after each cutting operation. Replace blades using the following procedure.

1. Fully retract the saw bow by reversing the autofeed or by using a wrench on the feed



Figure 6-14. To retract the bow manually, flip the feed nut clevis out and turn the nut counter-clockwise using a 5/8" wrench or socket.

2. Loosen the blade by turning the blade tension knob counterclockwise.



Figure 6-15. Turn the blade tensioning knob counter-clockwise to loosen the blade.

3. Using a 7/16" wrench, loosen the nut on the blade fastening plate and lift the blade from the mounting pin.

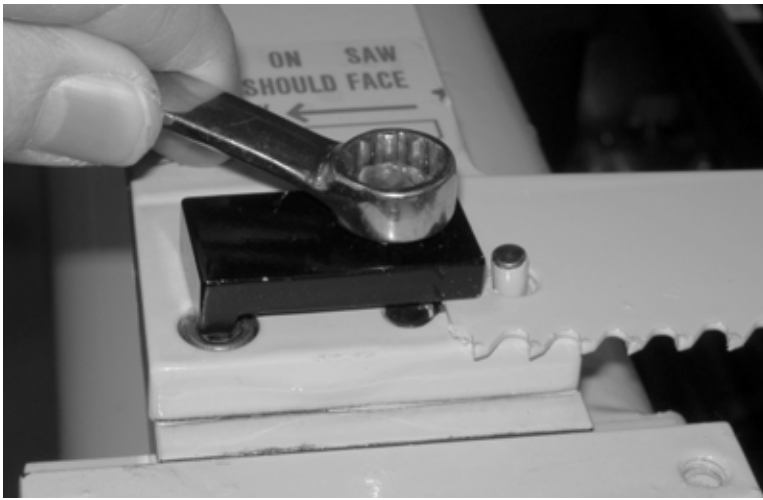


Figure 6-16. Loosen the blade fastening plate nut (7/16") and lift the plate to remove the blade.

4. Pull the blade off the mounting pins on both ends.
5. Insert the new blade onto the left mounting pin. Make sure the teeth point to the left as you face the machine. (See the blade direction labels on the saw bow.) Tighten the blade fastening plate nut.

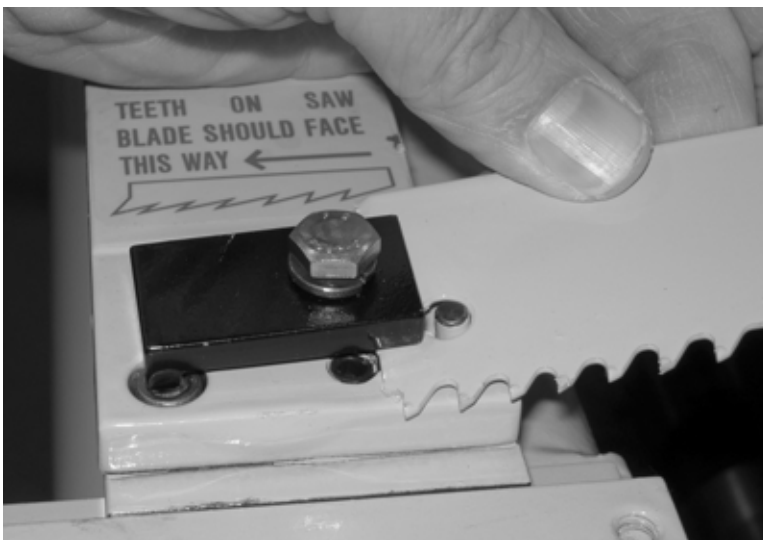


Figure 6-17. Put the blade on the mounting pin and tighten the nut to secure it under the fastening plate.



WARNING:

Use gloves to remove the worn blade. There may be sharp metal fragments on the blade.

6. Put the other end of the blade on the opposite pin.
Turn the blade tension knob clockwise until the blade is taut.

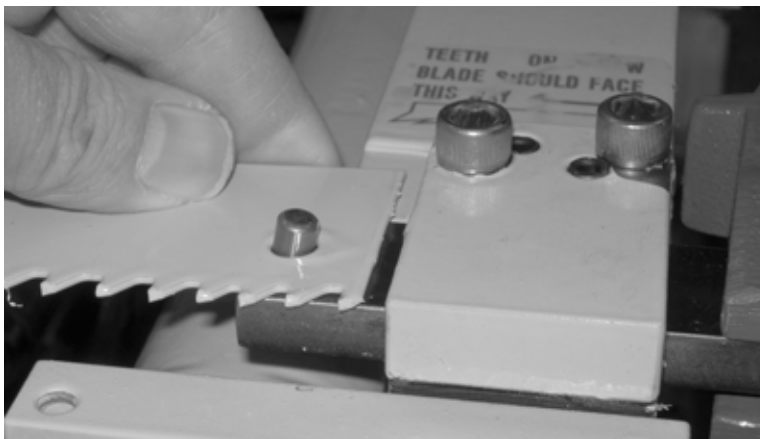


Figure 6-18. Hold the blade on the mounting pin while you tighten the blade tensioning knob.



Figure 6-19. Turn the blade tensioning knob clockwise to tighten the blade.

Chapter 7

Service and Repair

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The Guillotine Super C saw is a durable system with little required maintenance.

There are no user-serviceable components on the machine (except for replacement of the blade). Contact the E.H. Wachs Company if service is required. (See Chapter 10, “Ordering Information”.) Any service must be performed by a factory-authorized service representative.

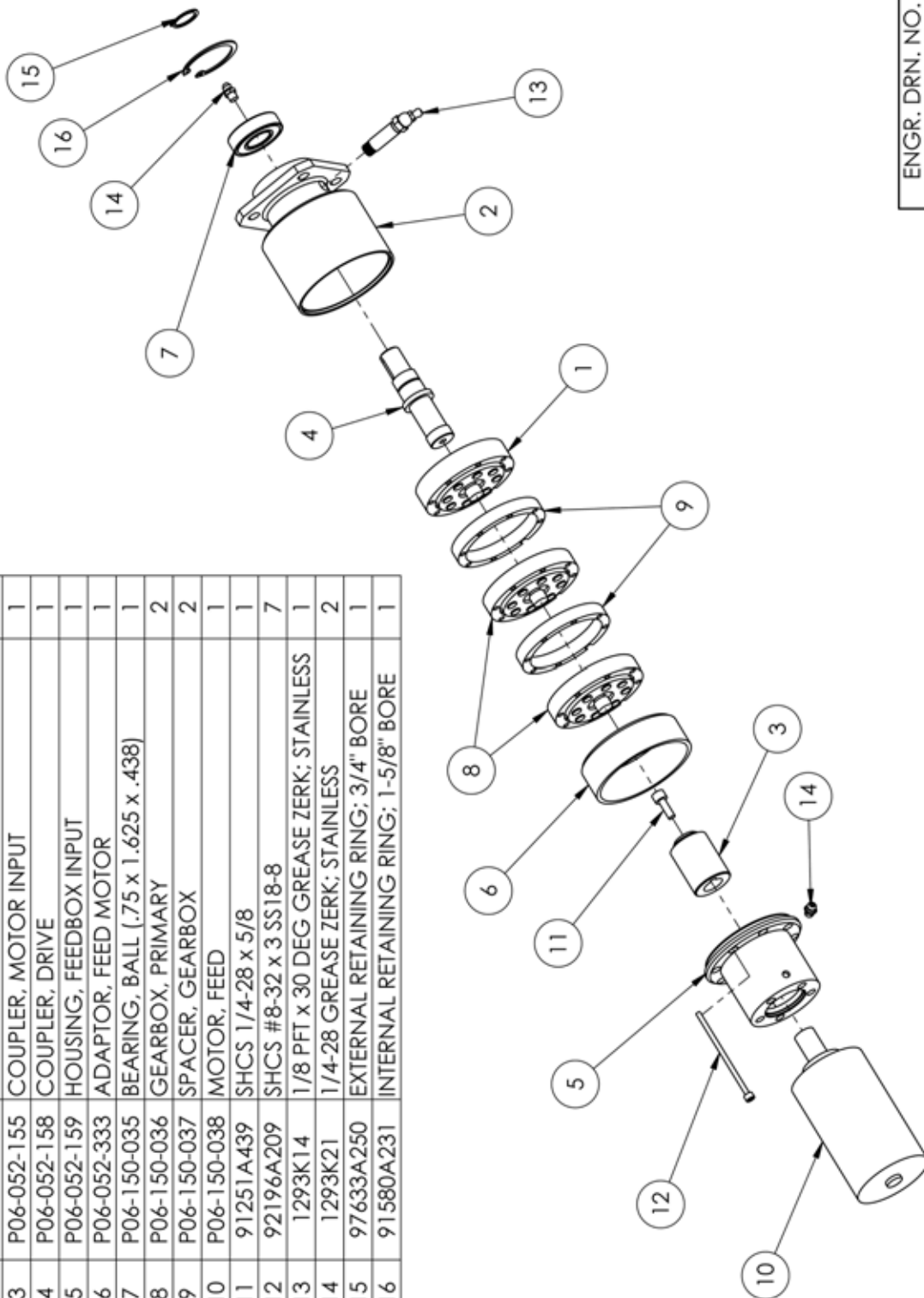
Chapter 8

Parts Lists and Drawings

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The following drawings illustrate the Super C Guillotine's components. Parts lists are included on the drawings. Call service at (800) 323-8185 for assistance in ordering.

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	11-103-00	GEARBOX, PLANETARY OUTPUT	1
2	P06-052-150	HOUSING, FEEDBOX OUTPUT	1
3	P06-052-155	COUPLER, MOTOR INPUT	1
4	P06-052-158	COUPLER, DRIVE	1
5	P06-052-159	HOUSING, FEEDBOX INPUT	1
6	P06-052-333	ADAPTOR, FEED MOTOR	1
7	P06-150-035	BEARING, BALL (.75 x 1.625 x .438)	1
8	P06-150-036	GEARBOX, PRIMARY	2
9	P06-150-037	SPACER, GEARBOX	2
10	P06-150-038	MOTOR, FEED	1
11	91251A439	SHCS 1/4-28 x 5/8	1
12	92196A209	SHCS #8-32 x 3 SS18-8	7
13	1293K14	1/8 PFT x 30 DEG GREASE ZERK; STAINLESS	1
14	1293K21	1/4-28 GREASE ZERK; STAINLESS	2
15	97633A250	EXTERNAL RETAINING RING; 3/4" BORE	1
16	91580A231	INTERNAL RETAINING RING; 1-5/8" BORE	1

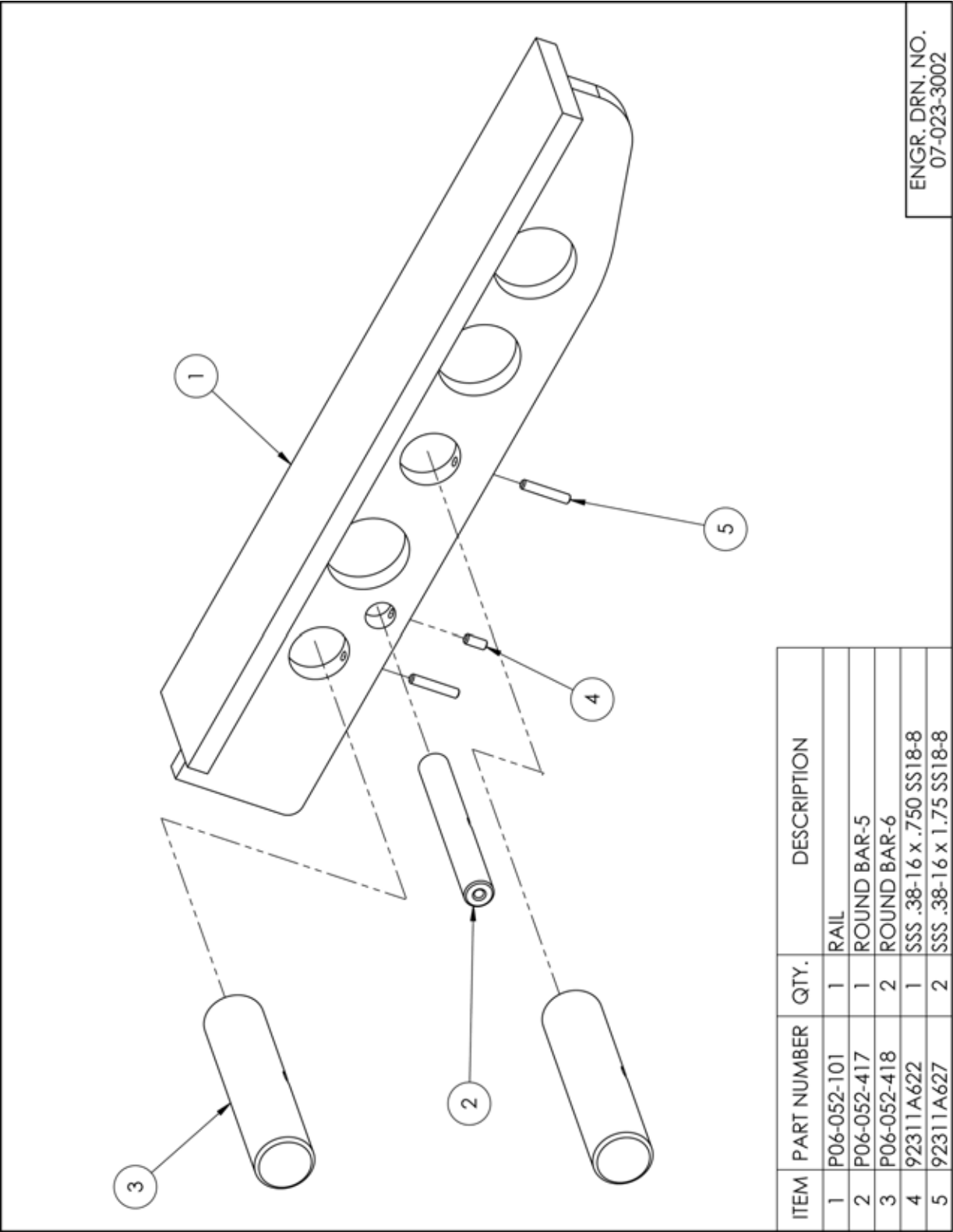


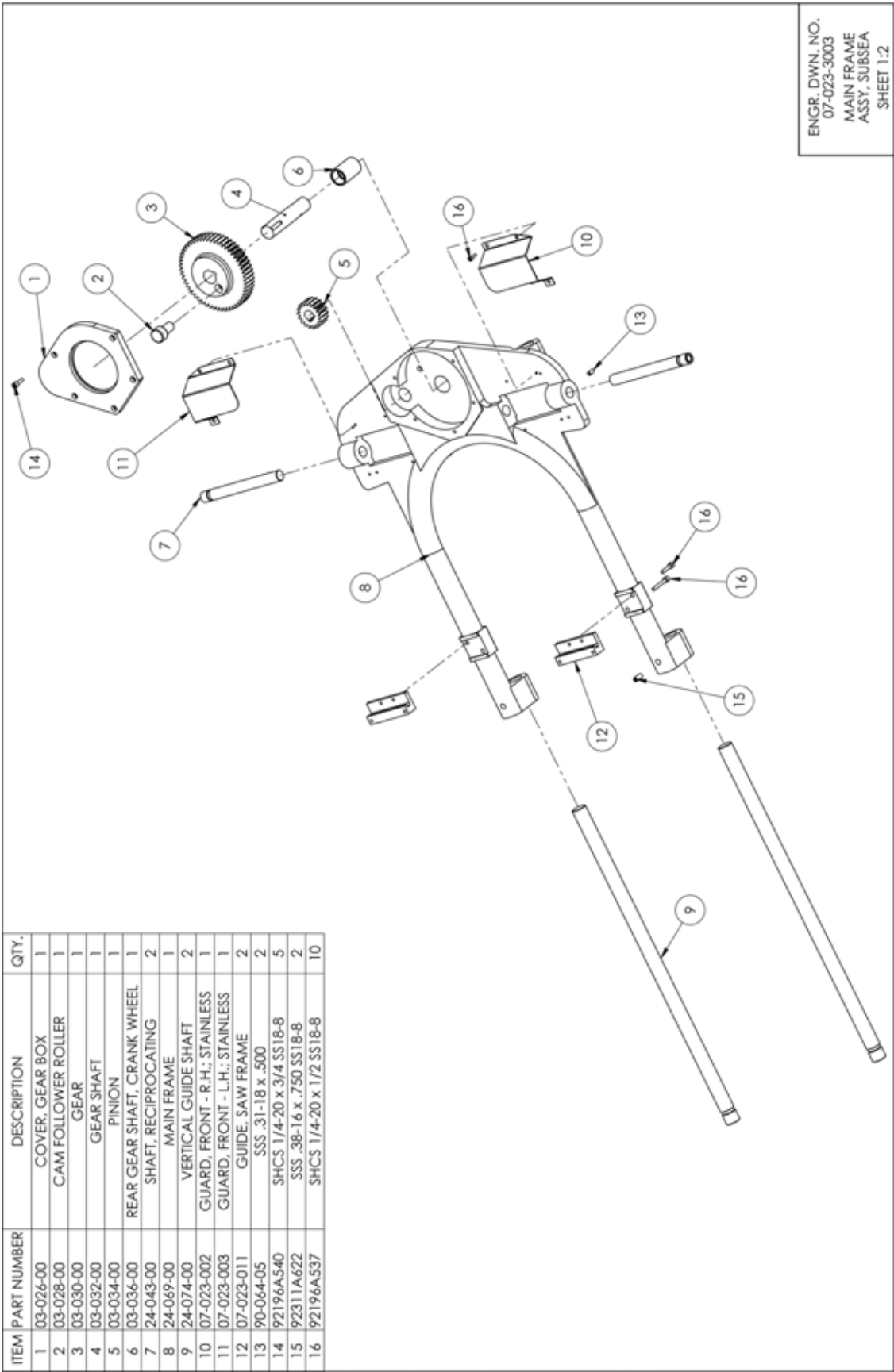
ENGR. DRN. NO.
07-023-3000 REV. 1

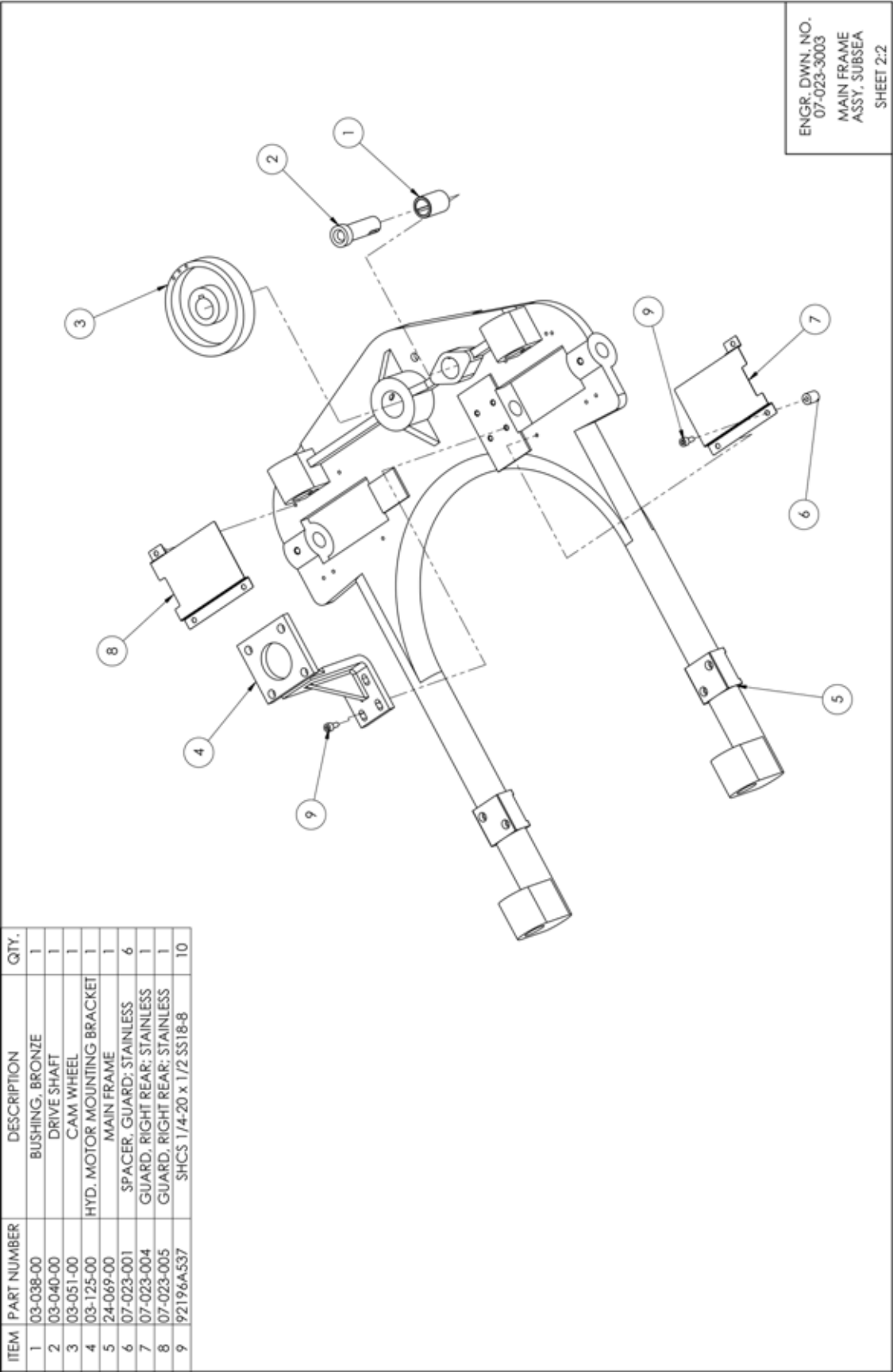
The diagram is an exploded view of a mechanical assembly. It shows various components including a main frame, a blade, a yoke, and various fasteners. The components are numbered 1 through 19. The assembly appears to be a blade holder or a similar mechanical device. The exploded view shows the relative positions and assembly sequence of the parts.

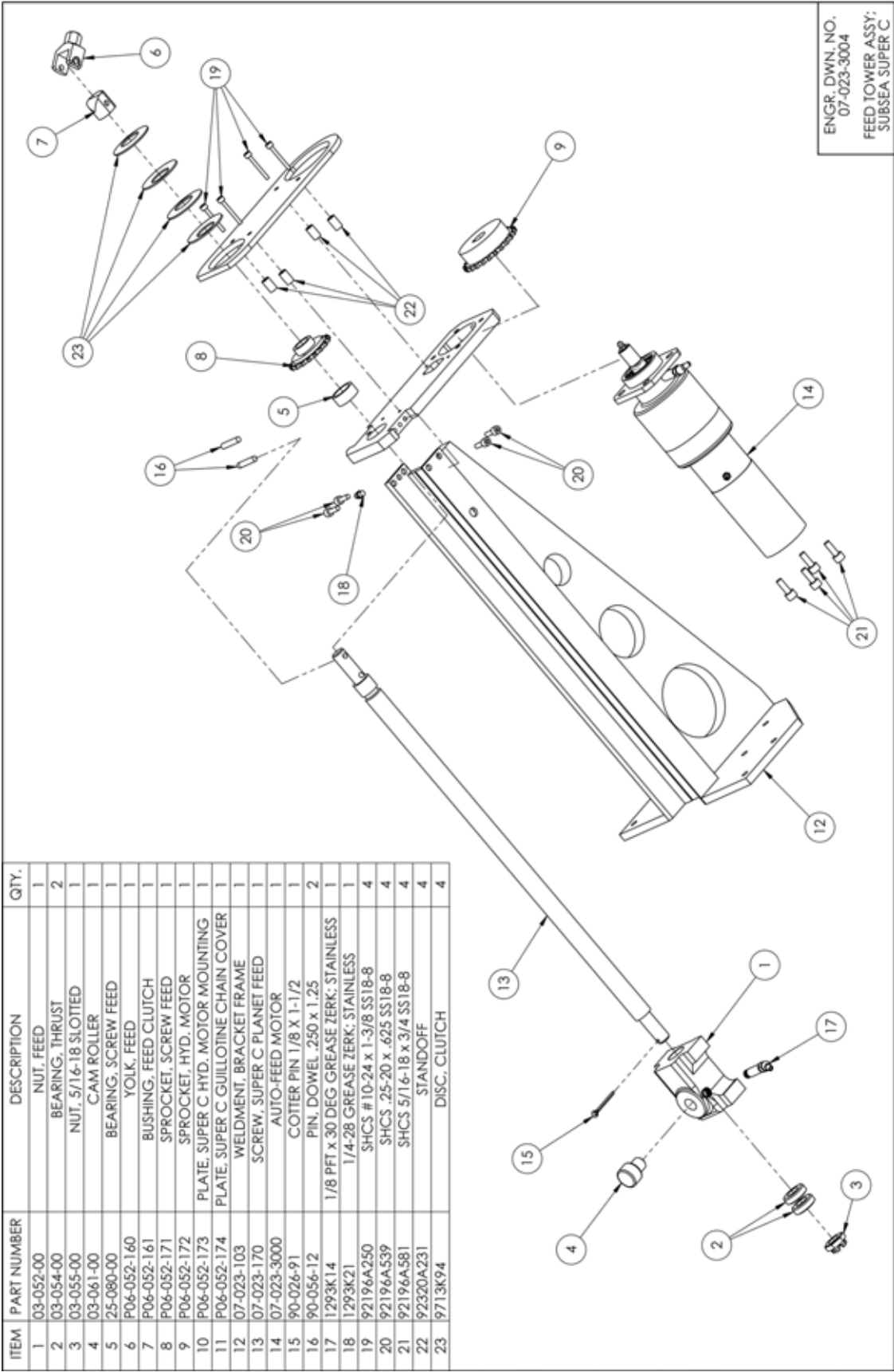
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-006-00	2	BUSHING, BRONZE
2	03-007-00	1	SCREW, TENSIONING
3	03-008-01	1	BRACKET, TENSIONING
4	03-009-00	1	KNOB, BLADE TENSIONING
5	03-020-00	1	BLADE HOLD-DOWN
6	03-206-00	2	BLOCK, BEARING
7	24-016-00	1	FRAME, SAW
8	07-023-006	1	GREASE COVER, YOKE; STAINLESS
9	07-023-009	1	YOKE
10	07-023-012	1	HOLDER, TENSIONER BAR
11	07-023-013	1	RAIL, SAW FRAME
12	90-056-06	4	PIN, DOWEL .250 x .625
13	90-056-58	2	PIN, ROLL 1/4 x 7/8
14	90-056-62	2	PIN, ROLL 1/4 x 1-1/4
15	92196A246	4	SHCS #10-24 x 7/8 SS18-8
16	92196A539	8	SHCS 1/4-20 x 5/8 SS18-8
17	92196A580	2	SHCS 5/16-18 x 5/8 SS18-8
18	92196A540	8	SHCS 1/4-20 x 3/4 SS18-8
19	92311A619	2	SSS .38-16 x .500 SS18-8

ENGR. DWN. NO.
07-023-3001

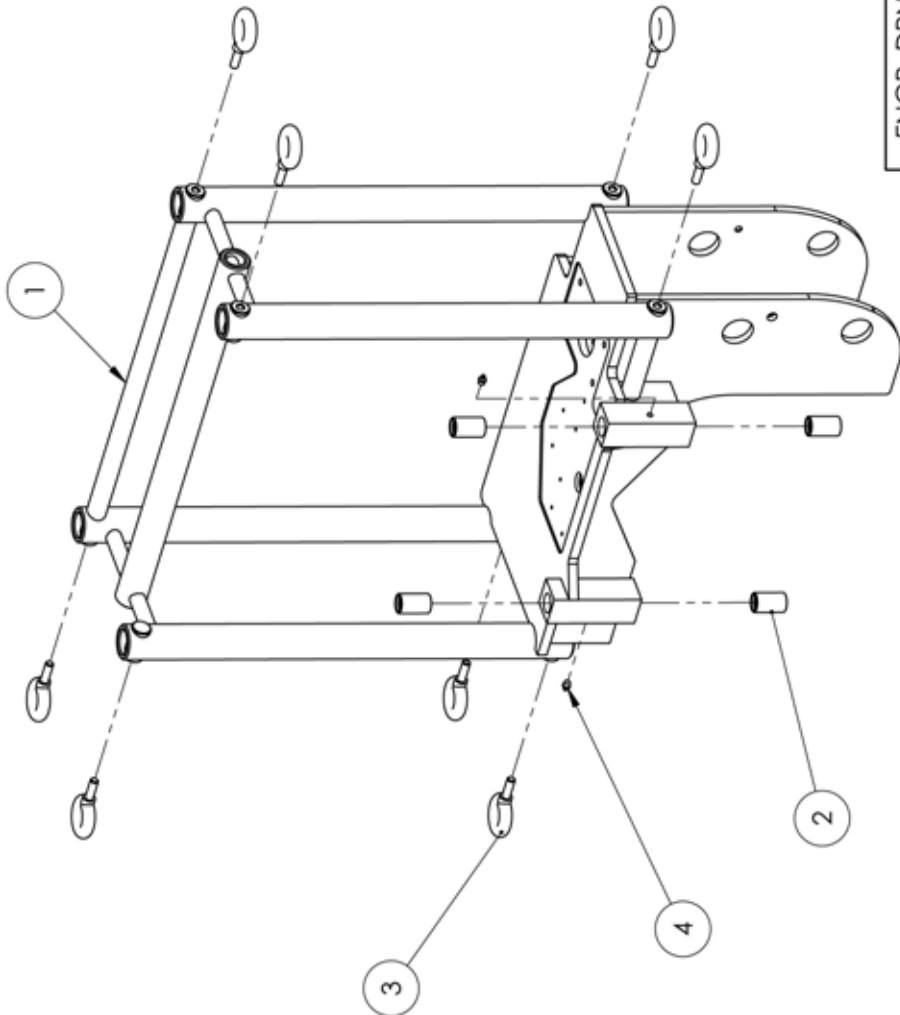




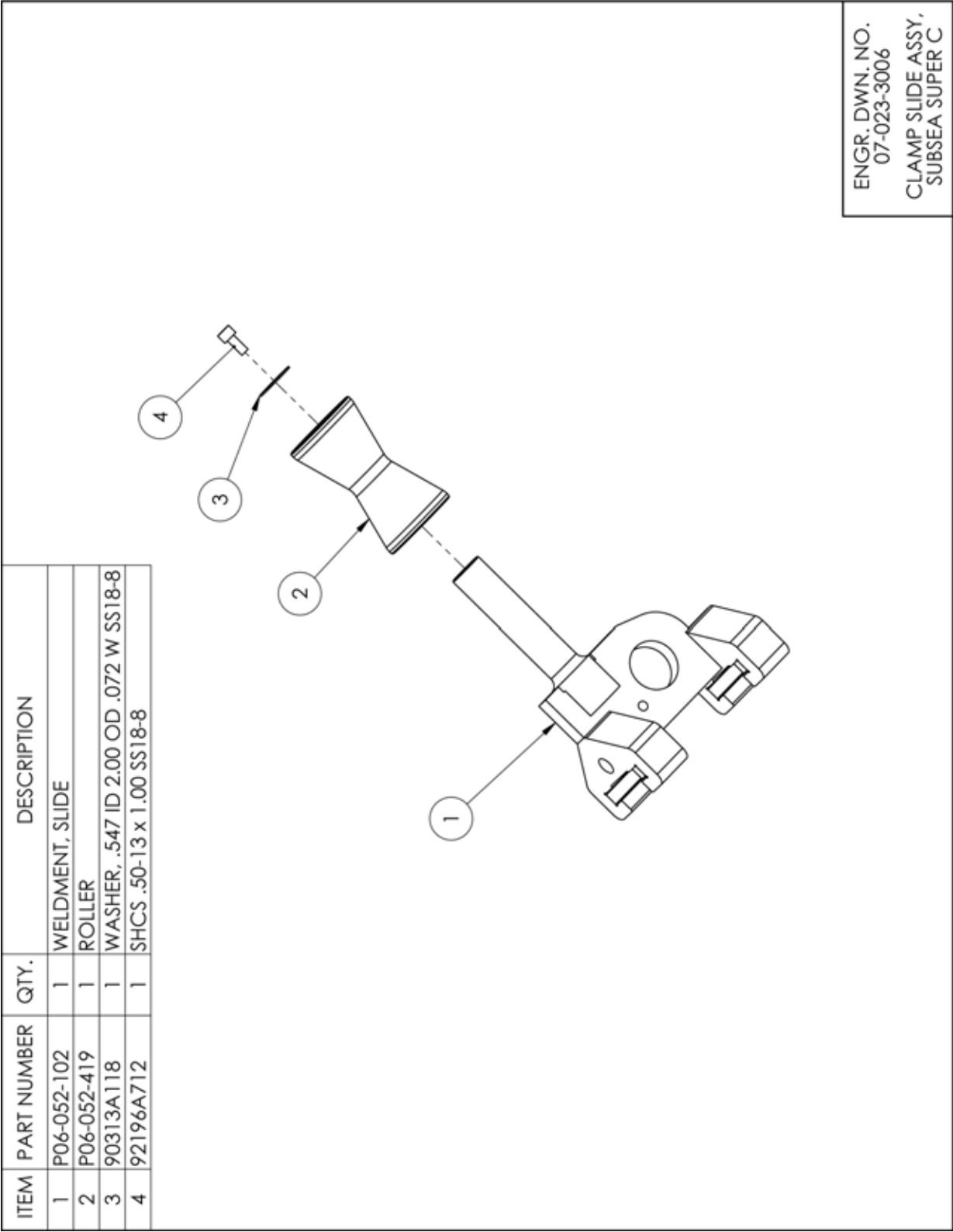




ITEM	PART NUMBER	DESCRIPTION	QTY.
1	07-023-100	WELDMENT, SADDLE	1
2	03-053-00	BUSHING, BRONZE	4
3	P06-052-452	EYEBOLT	8
4	90-500-02	GREASE FITTING, 1/8 NPT STR.	2



ENGR. DRN. NO.
07-023-3005
SADDLE ASSEMBLY



Chapter 9

Accessories

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The Super C Guillotine can be supplied with the following accessories:

- autofeed drive
- lifting frame
- hydraulic connector bulkhead for topside control.

You should keep a supply of spare blades.

Chapter 10

Ordering Information

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To place an order, request service, or get more detailed information on any E.H. Wachs Company products, call us at one of the following numbers:

U.S. 800-323-8185

International: 847-537-8800

ORDERING REPLACEMENT PARTS

When ordering parts, refer to the parts lists in Chapter 8. Please provide the part description and part number for all parts you are ordering.

REPAIR INFORMATION

Please call us for an authorization number before returning any equipment for repair or factory service. We will advise you of shipping and handling. When you send the equipment, please include the following information:

- Your name/company name
- Your address
- Your phone number
- A brief description of the problem or the work to be done.

In This Chapter

ORDERING REPLACEMENT PARTS

REPAIR INFORMATION

WARRANTY INFORMATION

RETURN GOODS ADDRESS

Before we perform any repair, we will estimate the work and inform you of the cost and the time required to complete it.

WARRANTY INFORMATION

Enclosed with the manual is a warranty card. Please fill out the registration card and return to E.H. Wachs Company. Retain the owner's registration record and warranty card for your information.

RETURN GOODS ADDRESS

Return equipment for repair to the following address.

Wachs Subsea LLC
11050 West Little York—Building N
Houston, TX 77041 USA